Blue

Dart Aerospace Ltd.

Date: Wednesday, 03/09/2008 10:25:50 AM
User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	**Drawing Name**	: 206/OH-58 SADDLE; INBOARD, RIGHT SIDE
Job Number	: 41714		
Estimate Number	: 10940		
P.O. Number	:	**Part Number**	: D29381
This Issue	: 03/09/2008 **S.O. No.** :	**Drawing Number**	: D2938 REV C - BLUE
Prsht Rev.	: NC	**Project Number**	: N/A
First Issue	: / / **Type** : MACHINED PARTS	**Drawing Revision**	: C
Previous Run	: 37424	**Material**	:
Written By	:	**Due Date**	: 26/09/2008 **Qty:** 3 **Um:** Each
Checked & Approved By	: JC 08.9.03		
Comment	: Est: B 00.06.26 New DWG rev (mpp 2069) EC Est Rev:C As per Rev C 07-03-19 JLM		

Additional Product

Job Number:

Seq. #:	Machine Or Operation:	Description :
1.0	D6101003	Saddle Billet, 7075

Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)
Issue material from stock: 7075-T7351 (QQ-A-250/12)
Cut Size 2.0" x 6.25" X 7.88" Grain Along 7.88" Length
(D6101-003) Batch No: 34373

SB 08/09/08

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1

Comment: HAAS CNC VERTICAL MACHINING #1
Program part number and batch number.
1-Inspect part number and batch number are programmed correctly.
2-Machine Step No 1 of Folio and visually inspect as per dwg D2938 & attached Dimension Sheet
3-Machine Step No 2 of Folio and visually inspect as per dwg D2938 & attached Dimension Sheet
4-Machine Step No 3 of Folio and visually inspect as per dwg D2938 & attached Dimension Sheet
5-Deburr

PM

SB 08/09/08 (3)

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE

Comment: CONVENTIONAL MILLING MACHINE
Machine Keyway and inspect per attached dimension sheet

08/09/09 (3)

4.0	QC1	INSPECT ALL DIM TO DIM SHEET

Comment: INSPECT ALL DIM TO DIM SHEET

08/09/09 (3)

Form: rprocess

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2938-1 PAR #: NA Fault Category: Prod / Machined Parts NCR: (Yes) No DQA: [signature] Date: 08/09/26

Resolution: ____ Disposition: ____ QA: N/C Closed: [signature] Date: 08/09/26

NCR: 41714		WORK ORDER NON-CONFORMANCE (NCR)						
			Corrective Action Section B					
DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector
08/09/08	2.0	First part origin was off. So the dimension of .540 .550 was .538 On 4 operation	[signature] 08/9/15	SCRAP and Destroy AND Replace Qty 40 B# 34873	[signature] 08/09/08	[signature] 08/01/15	[signature] 08/09/15	[signature] 08/01/09
		when facing have a lot of vibration. R.C. operator ERROR						
8/9/9	# 2.0	Bore to skidtube is 0.095" wall. supposed to be 0.105" to 0.140" R.C operator error	[signature] 08/09/15	SCRAP [initials] 08.09.09 and Destroy and Replace Qty 40 B# 34873	[signature] 08/09/09	[signature] 08/01/15	[signature] 08/09/15.	[signature] 08/01/09

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

Date: Wednesday, 03/09/2008 10:25:50 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** 206/OH-58 SADDLE, INBOARD, RIGHT SIDE

Job Number: 41714 **Part Number:** D29381

Job Number:

Seq. #:	Machine Or Operation:	Description :
5.0	QC8	SECOND CHECK
	Comment: SECOND CHECK	08/09/15
6.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
	Comment: HAND FINISHING RESOURCE #1 Acid etch and Alodine as per QSI 005 4.1	08-09-16 (X3)
7.0	SPRAY PAINTING	SPRAY PAINTING
	Comment: -PRIME B106729 -SPRAY PAINT DELFLEET BLUE B105918 -CLEAR DELFLEET B109333	08 09 23 (3)
8.0	QC14	INSPECT SPRAY PAINT
	Comment: INSPECT SPRAY PAINT	08.09.25
9.0	PACKAGING 1	PACKAGING RESOURCE #1
	Comment: PACKAGING RESOURCE #1 Identify and Stock Location: 445	8/9/25 SY
10.0	QC21	FINAL INSPECTION/W/O RELEASE
	Comment: FINAL INSPECTION/W/O RELEASE	08/09/26
Job Completion		08.09.25

Form: rprocess

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

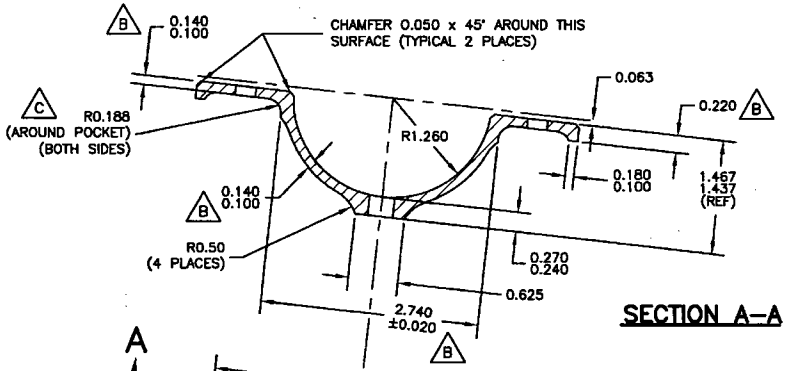
DART AEROSPACE LTD	Work Order:	41714
Description: 206 Saddle, Outboard, Left side	**Part Number:**	**D2938-1**
Inspection Dwg: D2938 Rev. C		**Page 1 of 1**

Inspect dimensions highlighted on inspection sheet drawing D2938 Rev. C and record below:

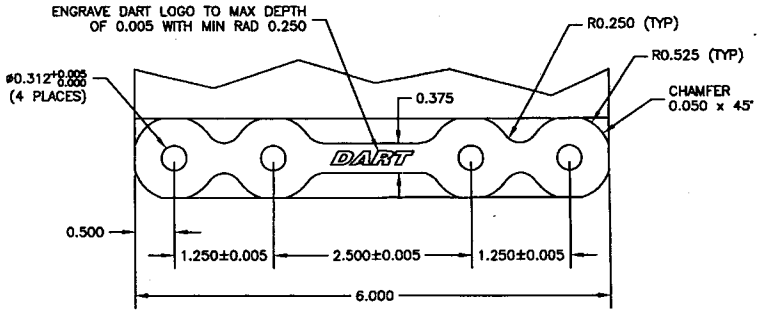
				Recorded Actual Dimensions					
Dim	**Min**	**Max**	**Go/No Go Gauge**	**1**	**2**	**3**	**4**	**By**	**Date**
A	0.100	0.140		.138	.138	.138			
B	0.100	0.140		.138	.138	.138			
C	0.100	0.140		.140	.140	.140			
D	0.210	0.230		.221	.221	.221			
E	1.245	1.255		1.250	1.250	1.250			
F	1.245	1.255		1.250	1.250	1.250			
G	2.495	2.505		2.500	2.500	2.500			
H	0.510	0.515		.510	.510	.511			
I	1.572	1.582		1.577	1.577	1.577			
J	2.495	2.505		2.500	2.500	2.500			
K	0.257	0.262		.258	.258	.258			
L	0.312	0.317		.317	.317	.317			
M	0.235	0.240		.238	.238	.239			
N	0.100	0.140		.110	.110	.110			
O	0.540	0.560		.540	.545	.550			
P	0.490	0.510		.500	.500	.503			
Q	3.715	3.725		3.718	3.718	3.718			
R	2.720	2.760		2.743	2.743	2.743			
S	0.240	0.270		.250	.250	.250			
T	0.100	0.180		.135	.135	.135			
U	1.625	1.635		1.628	1.628	1.628			
V	1.362	1.372		1.366	1.366	1.366			
W	0.316	0.321		.320	.320	.320			
X	1.250	1.270		1.256	1.260	1.260			
Y	1.565	1.585		1.570	1.577	1.577			
Z	0.178	0.198		.188	.188	.188			
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:		Audited by:	
Date:	08/09/08 / 08/09/09	Date:	08/09/15

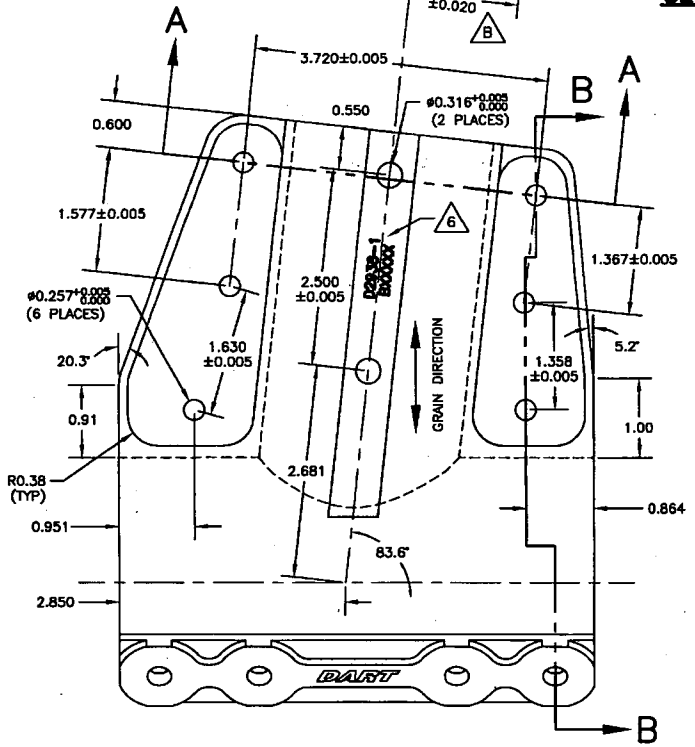
Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	



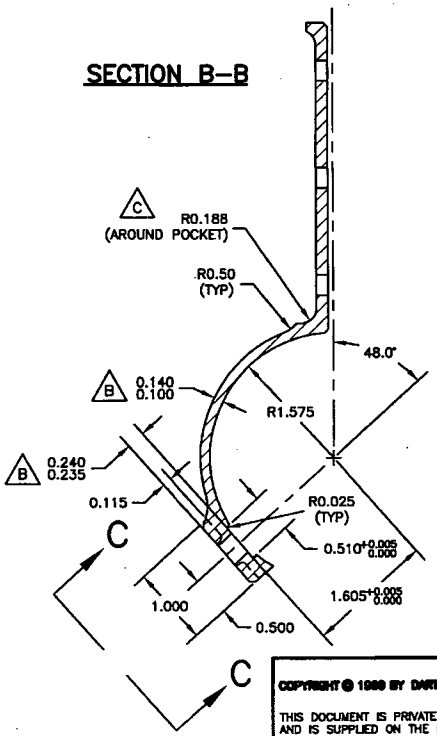
SECTION A–A



VIEW C–C



SECTION B–B



D2938–1 LH SADDLE (SHOWN)

D2938–2 RH SADDLE (OPPOSITE)

NOTES:

1) MATERIAL: ALUMINUM 7075–T7351 (QQ–A–250/12) (MAKE FROM D6101–003 SADDLE BILLET, 7075)
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
3) BREAK ALL SHARP EDGES 0.010 TO 0.020
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
5) ALL DIMENSIONS ARE IN INCHES
6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP

C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.11.12	NEW ISSUE

DESIGN	DRAWN BY	DART AEROSPACE USA, INC. BELLEVUE, WA	
CHECKED	APPROVED	DRAWING NO. D2938	REV. C SHEET 1 OF 1
DATE 06.11.09		TITLE SADDLE OUTSIDE	SCALE 2:3